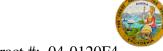
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES
Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453

(707) 649-5493



Contract #: <u>04-0120F4</u>

Cty: <u>SF/ALA</u> Rte: <u>80</u> PM: <u>13.2/13.9</u>

File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter Report No: WIR-026339
Address: 333 Burma Road Date Inspected: 24-Apr-2011

City: Oakland, CA 94607

Project Name:SAS SuperstructureOSM Arrival Time:1500Prime Contractor:American Bridge/Fluor Enterprises, a JVOSM Departure Time:300

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island Location: Shanghai, China

CWI Name: CWI Present: Yes Lv Li Qing No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No Yes N/A **Delayed / Cancelled:** No

Bridge No: 34-0006 Component: OBG

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08819.

Magnetic Particle Testing (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG. The weld designations reviewed is as follows:

SEG3019R-002, 006, 010, 014, 018, 022, 026, 030, 034, 038, 004, 008, 012, 016, 020, 024, 028, 032, 036

SEG3019AB-051~058, 067~076, 085~088

WELDING

Bay 14

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as SEG3020U-587 located on side plate to anchor plate of the OBG Segment 14W. The welder is identified as 045246. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as VP3018-001-003 located on vertical plate of the OBG Segment 14W. The welder is identified as 070007. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as TR3008TR2-001-021 located on traveler rail. The welder is identified as 066674. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3172-001-389 located on deck late of the OBG Segment 14W. The welder is identified as 067949. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3020V-028 located on deck panel diaphragm to deck panel diaphragm of the OBG Segment 14W. The welder is identified as 045175. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

Submerged Arc Welding (SAW)

This QA Inspector observed the welding operation per the SAW process on a weld joint identified as SEG3020*-011 located on deck panel of the OBG Segment 14W. The welder is identified as 045270. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Singh, Vikram	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer